

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 1

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4168

A

IIN-D350-636

H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-015 CHG 001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 2

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, LH

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168.

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D4168. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .210" (total of 1 hole per side)

① D JE 11/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM

Page 3

Item ID: D350-636-015

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: 11

M116577

BE 11/02/14

12-Grind welds flush as per Dwg D4168

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/02/14

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/02/14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM

Page 4

Item ID: D350-636-015

Accept

Revision ID:

Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 2/4/2011 Start Qty: 1.00

Required Date: 2/18/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



1 11-2-15
BE 11/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM

Page 5

Item ID: D350-636-015

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

Open wearplate holes to size as per dwg (4 holes per sides)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1
& QSI004

(welding instructions on sheet 8)

A/R

Aluminum Rod

batch:

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 11/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 6

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

12- C'bore section CG-CG

13- Deburr holes

BE 11/02/17

170



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DU 11/02/18

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM

Page 7

Item ID: D350-636-015

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

⇒ M. 11/02/28

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

M 115951.

0.00

Powder Coating

Memo

START TIME: 11:05
OVEN TEMPERATURE: 320°
FINISH TIME: 11:35

1 BF 11-02-28.

205

Wing Walk as per dwg QSI005 4.4 Batch

0.00

HandFinish

Memo

0.00

Hand Finishing

W/A per previous W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 8

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

220

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D4168

1 7 1103101

1 0 1103101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM

Page 9

Item ID: D350-636-015

Accept

Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00

Required Date: 2/18/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M1A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

SIKA FLEX 241

BATCH: M115114

EXP DATE: 11/01

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon" batch: M114396

240

QC5-Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

1 0 20 4/03/01

5/03/01

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 10

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/2/11

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

Sub 3/01

70

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-015

Location: _____

PPP rev: _____

PP 63132

11/3/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66105

Monday, February 07, 2011 7:24:43 AM



Page 11

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD w/ Training Wearplates. LH

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01 *[Signature]*
CL 11/03/01

Picklist Print

Monday, February 07, 2011 7:24:38 AM

Page 1

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A BOLT		Purchased	No			230	Each	73.0000	1	1			

Location	Loc Qty	Loc Code
ST353	73	
115767	3	
116003	20	
116075	50	

AN3C36A BOLT		Purchased	No			230	Each	101.0000	4	4			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST353	101	
109771	6	
116050	8	
116381	37	
116590	50	

AN3C37A BOLT		Purchased	No			230	Each	8.0000	1	1			
-----------------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST353	1	
114801	1	
ST354	7	
116381	7	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:38 AM

Page 2

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased No

230 Each

68.0000

1

1

BOLT

Location

Loc Qty

Loc Code

ST354

68

106176

68

AN960JD816

Purchased No

250 Each

89.0000

2

2

1/2" washer, Alum

Location

Loc Qty

Loc Code

ST348

89

106043

89

D3873-1

Manufactured No

230 Each

209.0000

7

Bushing

Location

Loc Qty

Loc Code

ST089

100

64567

100

ST092

106

62197

4

63314

2

64760

100

ST093

3

57615

3

D4154-041

Manufactured No

230 Each

0.0000

1

1

Wearplate Assembly

B65092

Monday, February 07, 2011 7:24:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:39 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

D4170-1 Manufactured No

230

Each

3.0000

4

4



Bushing

Location

Loc Qty

Loc Code

LG

3

63322

3

D4171-1 Manufactured No

230

Each

22.0000

1

1



Bushing

Location

Loc Qty

Loc Code

ST135

22

62710

2

65646

20

MS21043-3 Purchased No

230

Each

1.422.000

5

5



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1346

112314

1346

NAS1149C0363R Purchased No

230

Each

5,147.000

9

9



Washer

Location

Loc Qty

Loc Code

ST297

5147

113524

33

113889

210

114742

4904

BE 1/10/10

366158 x 4

11/1/10

11/1/10

11/1/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:39 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased No

230

Each

308.0000

4

4



WASHER



1.1 hrs

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

268

111819

34

113362

234

D2744

Manufactured No

110

Each

57.0000

1

1



Cap



BE 11/2/10

Location

Loc Qty

Loc Code

LG

29

65086

29

ST

28

62715

28

D2600-3-BENT

Manufactured No

110

Each

8.0000

1

1



Extrusion Bent



BE 11/2/10

Location

Loc Qty

Loc Code

LG

8

61634

2

62764

1

64434

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:39 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 138.0000 8 8



Crossbolt Spacer



BE 11/02/16

Location Loc Qty Loc Code

LG 138
50281 10
57953 2
59111 10
61844 32
64003 84

8

D2739 Manufactured No 160 Each 6.0000 1 1



350 I Beam



BE 11/02/14

Location Loc Qty Loc Code

LG 6
64448 6

1

D3490-3 Manufactured No 160 Each 43.0000 4 4



Cross Bolt Spacer



BE 11/02/16

Location Loc Qty Loc Code

LG 43
60294 1
63556 24
64006 18

4

D3490-1 Manufactured No 160 Each 69.0000 4 4



Cross Bolt Spacer



BE 11/02/16

Location Loc Qty Loc Code

LG 69
59424 3
62450 52
64005 14

4

Monday, February 07, 2011 7:24:39 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:40 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

4,020.000

4

4



Insert

Location

Loc Qty

Loc Code

PK011

4020

110768

4020

230

Each

93.0000

8

8

D3492-041

Manufactured

No



Plug Assembly

Location

Loc Qty

Loc Code

FP013

93

59114

1

62210

3

63994

29

65068

60

AN8C35A

Purchased

No

230

Each

36.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST346

36

114442

5

115188

5

115960

26

D3488-041

Manufactured

No

230

Each

17.0000

1

1



Blade Fitting Assembly, LH

Location

Loc Qty

Loc Code

FG008

10

62002

10

FP18

7

61689

7

Monday, February 07, 2011 7:24:40 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/03/01	270	Assemble with NAS 1611-013 / M116582 10" rings	ju	11/03/01	X8			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:40 AM

Page 7

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased No

230 Each

47.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

45

111649

2

114653

1

115936

42

MS21083C8

Purchased No

230 Each

43.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884

31

D3631-I

Manufactured No

230 Each

144.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST072

144

63647

144

AN960C10L

NAS1149C0332

Purchased No

230 Each

25.0000

4

4



washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

Monday, February 07, 2011 7:24:40 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:40 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 121.0000 8 8



Bushing

Location Loc Qty Loc Code

ST023 121
52311 5
59112 4
61988 4
63315 108

_____ *HL 1103101*

_____ *x8*

AN960C816L Purchased No 230 Each 0.0000 1 1



NAS 149C08332R/ M114915

WASHER

D3492-043 Manufactured No 230 Each 41.0000 8 8



Plug Assembly

Location Loc Qty Loc Code

FP 2
54682 2
FP013 39
59117 1
59190 4
63996 2
65070 32

(x1) HL 1103101
HL 1103101 PTO =)

AN3C6A Purchased No 230 Each 359.0000 4 4



BOLT

Location Loc Qty Loc Code

ST351 359
111982 134
~~116419~~ 75
116549 50
116704 100

11/2/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/01	230	Assemble with NAS 1411-010 / M110915 'O rings	JL	11/03/01	K8		11/03/01

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:40 AM

Work Order ID: 66105

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

546.0000

4

4



NUT

Location

Loc Qty

Loc Code

ST301

546

112314

546

250

Each

32.0000

2

2

D3493-1

Manufactured

No



Washer

Location

Loc Qty

Loc Code

ST062

32

62677

32

250

Each

43.0000

2

2

MS21083C8

Purchased

No



NUT

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884

31

250

Each

71.0000

2

2

AN8C21A

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST345

71

113558

1

114653

2

115723

8

116381

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 7:24:41 AM

Page 10

Work Order ID: 66105



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

79.0000



1

11/2/2011



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

79

60210

6

61341

33

63589

40

1

Monday, February 07, 2011 7:24:41 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

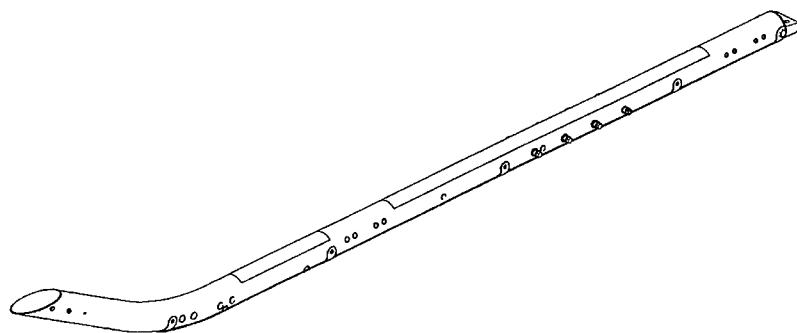
GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

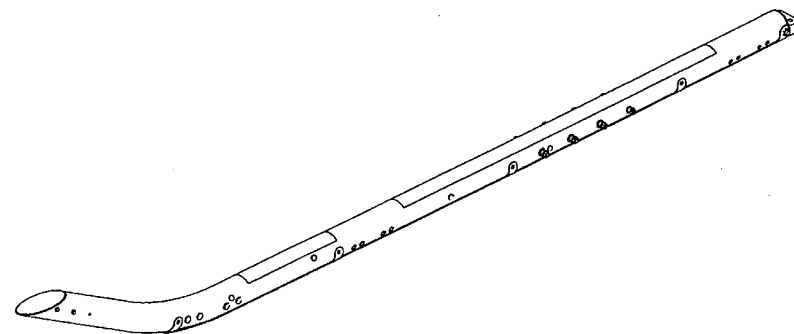
66105

RELEASED
R 2010-09-15 D

A		NEW ISSUE		SC	10.08.09
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4168	SHEET 1 OF 11		
APPROVED		TITLE	SCALE		
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS		
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



D4168-041 350 SKIDTUBE ASSEMBLY, LH

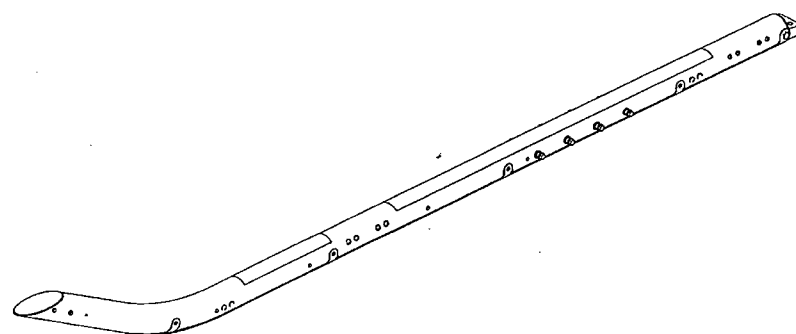


D4168-042 350 SKIDTUBE ASSEMBLY, RH

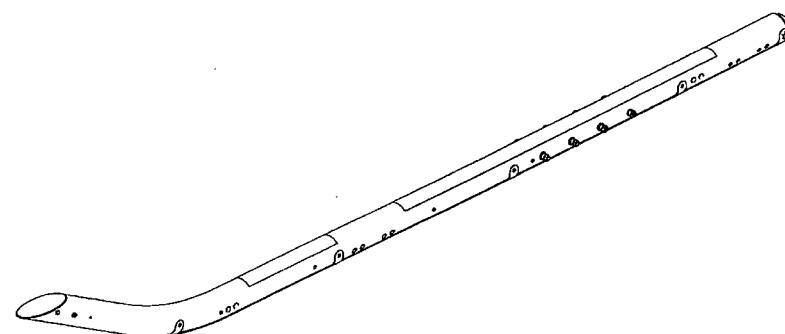
60105

RELEASED
2010-09-15
JW

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4168-043 350 SKIDTUBE ASSEMBLY, LH

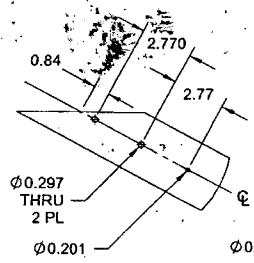


D4168-044 350 SKIDTUBE ASSEMBLY, RH

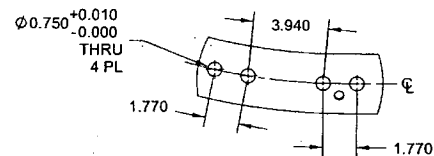
6/10/05

RELEASED
2010-09-15

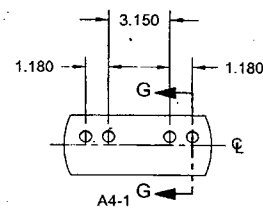
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



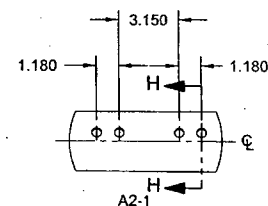
DETAIL A
SCALE 2X



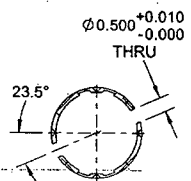
DETAIL B
SCALE 2X



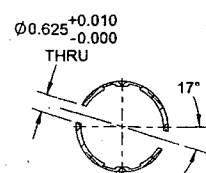
DETAIL C
SCALE 2X



D3-4
DETAIL D
SCALE 2X

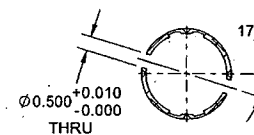


D6-4
SECTION E-E
SCALE 3X, 2 PL



B4-4

SECTION G-G
SCALE 3X, 4 PL



SECTION H-H B2-4
SCALE 3X, 4 PL

RELEASED
2010-09-15

8

7

6

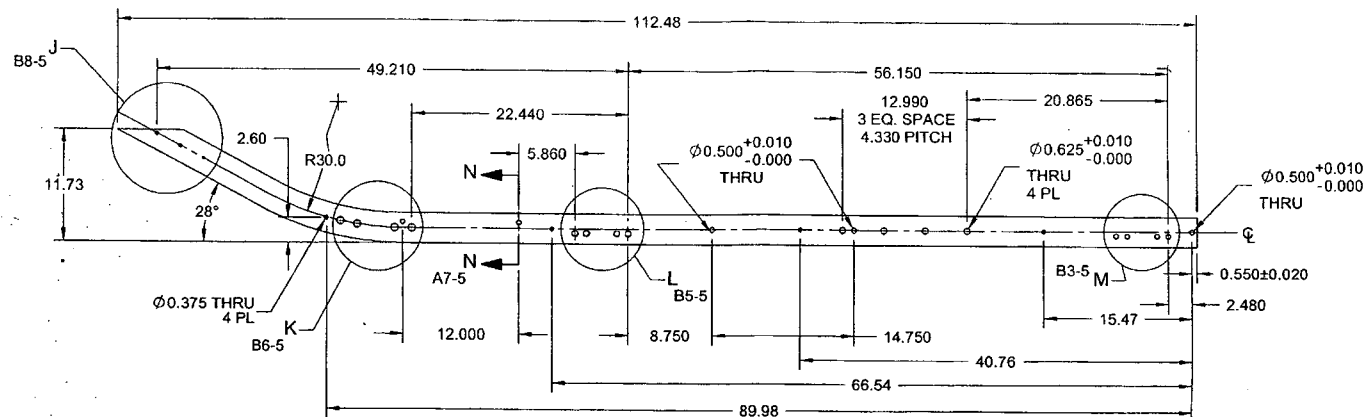
5

4

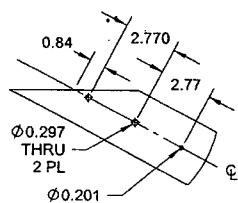
3

2

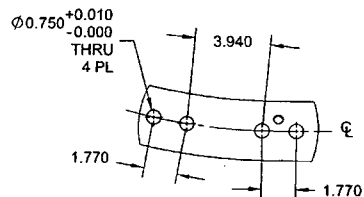
1



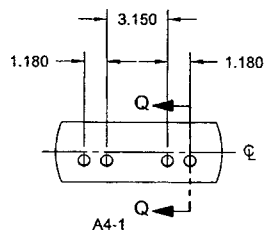
D4168-2 RH SKIDTUBE



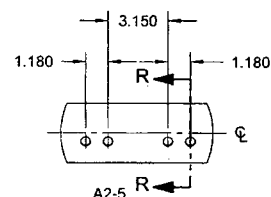
DETAIL J
SCALE 2X



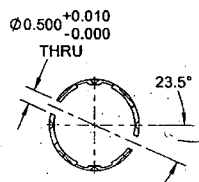
DETAIL K
SCALE 2X



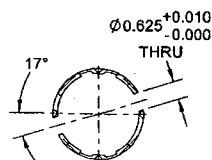
DETAIL L
SCALE 2X



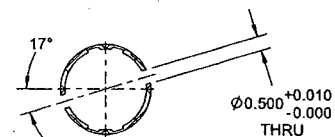
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



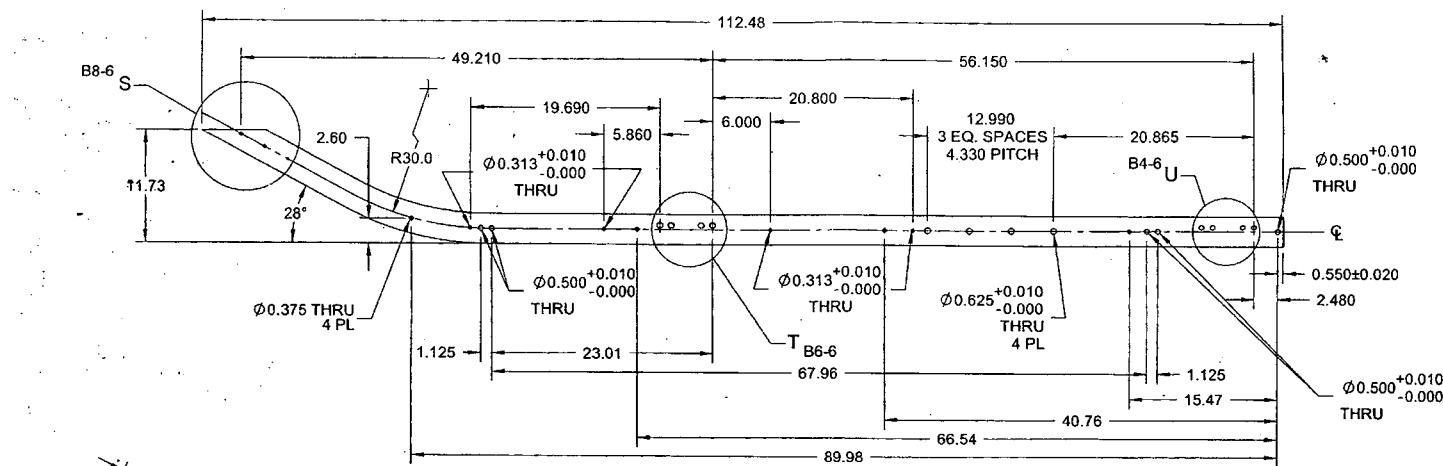
SECTION R-R
SCALE 3X, 4 PL

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS.
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

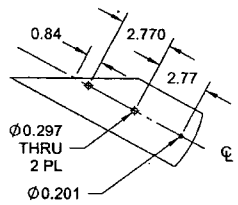
RELEASED
2010-09-15

66105

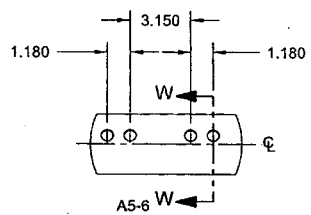
8 7 6 5 4 3 2 1



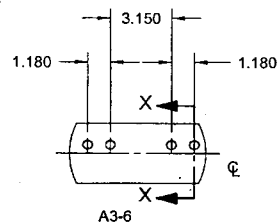
D4168-3 LH SKIDTUBE



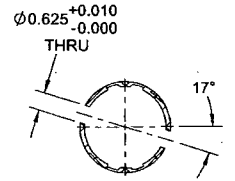
DETAIL S
SCALE 2X



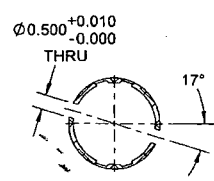
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

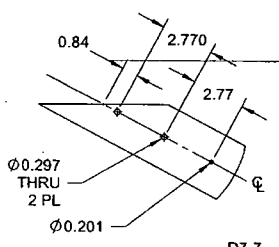
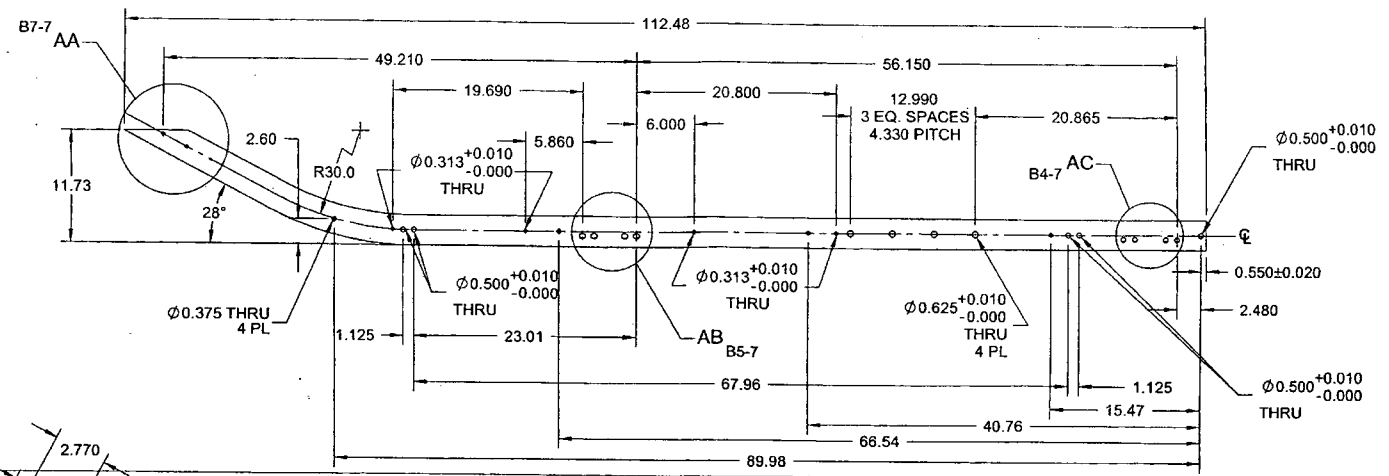
66105

RELEASED
2010-09-15

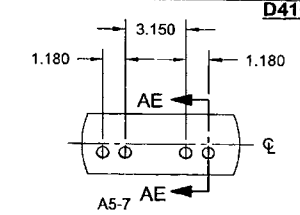
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

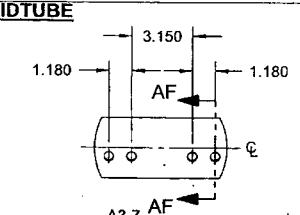
8 7 6 5 4 3 2 1



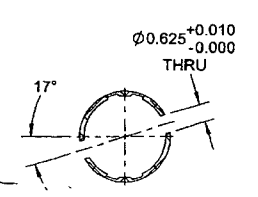
DETAIL AA
SCALE 2X
D7-7



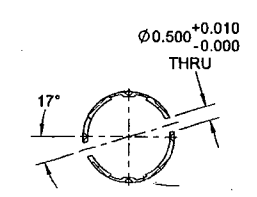
DETAIL AB
SCALE 2X
C4-7
A5-7 AE



DETAIL AC
SCALE 2X
D3-7
A3-7 AF



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

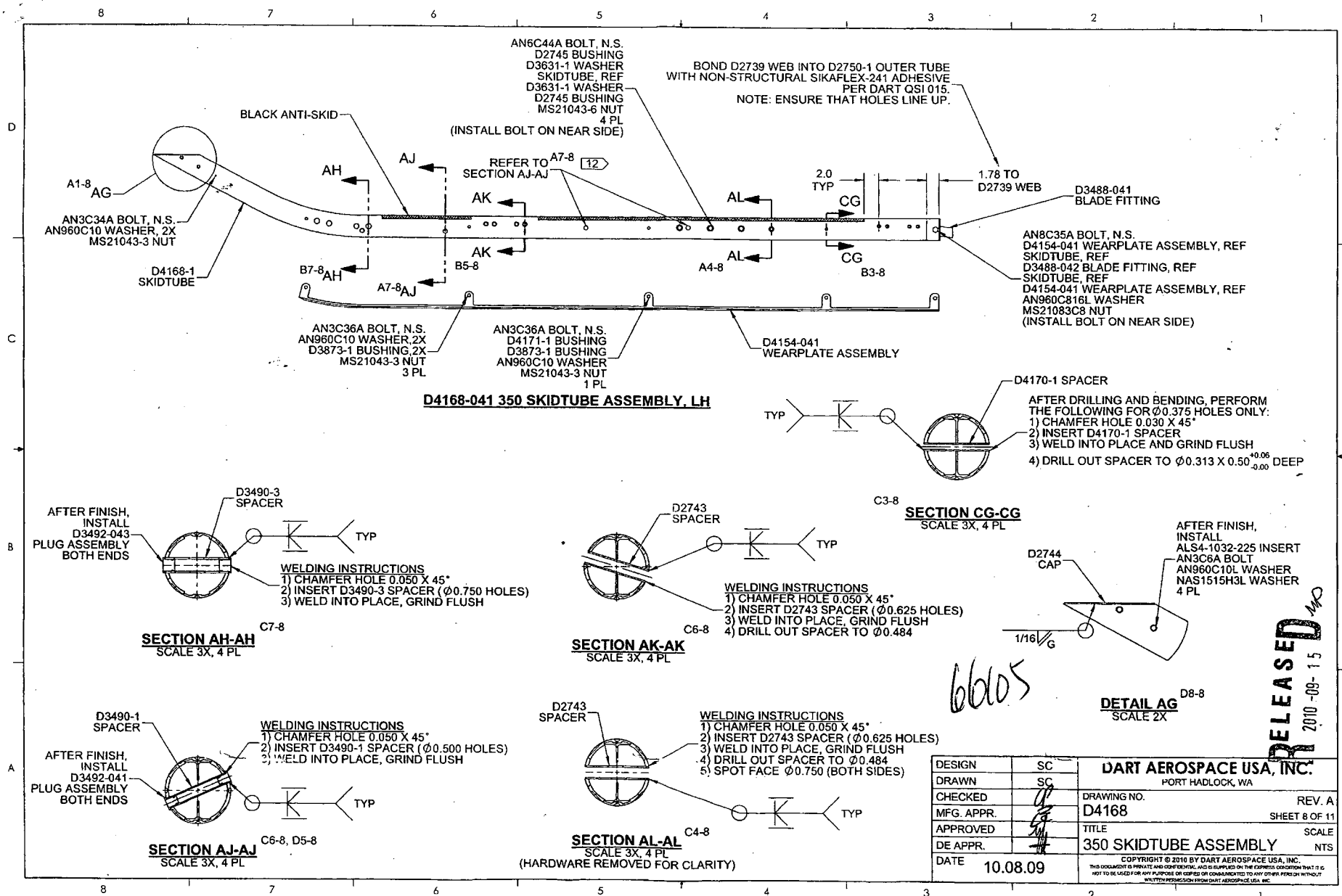
D4168-4 RH SKIDTUBE

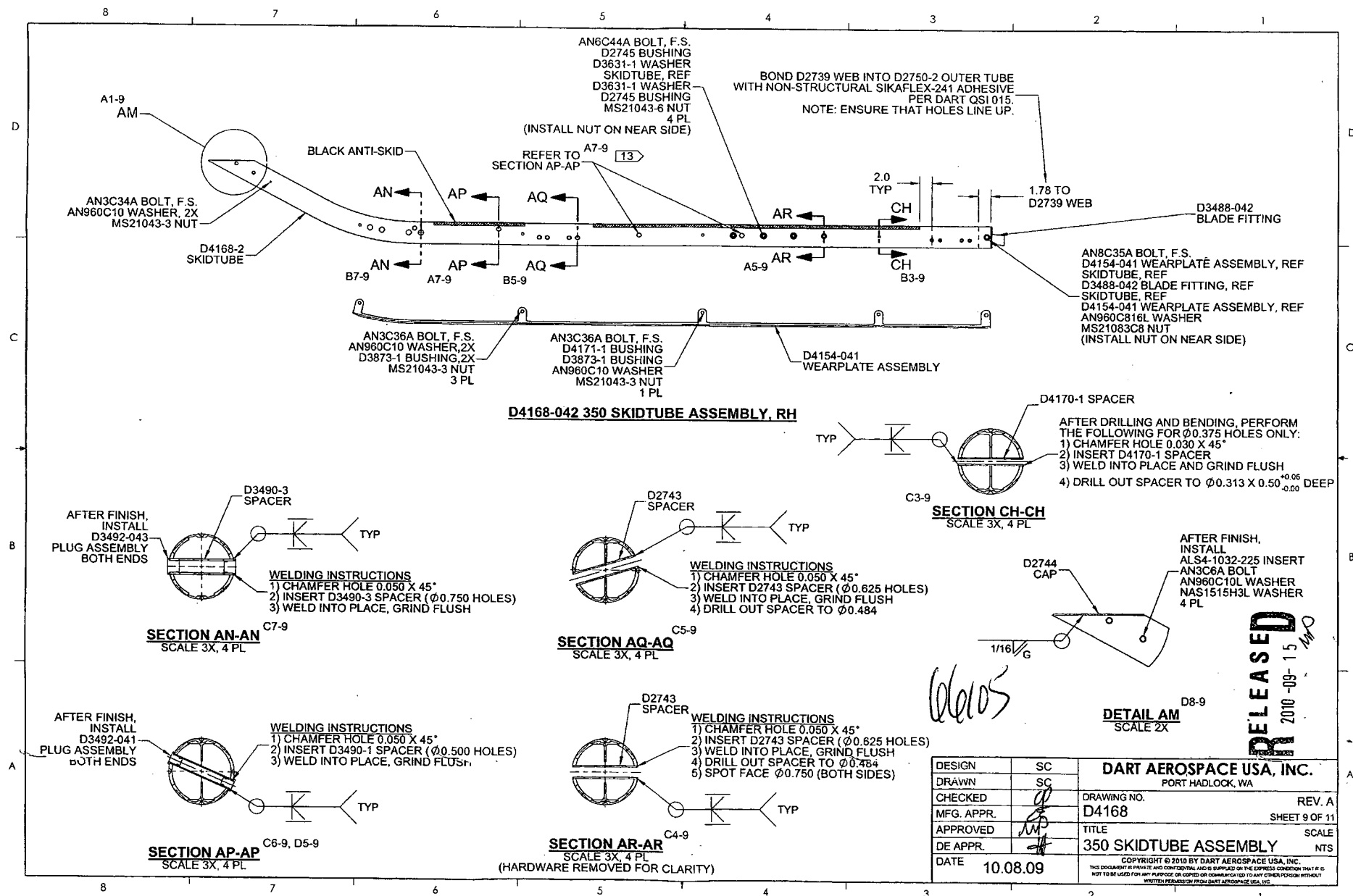
66105

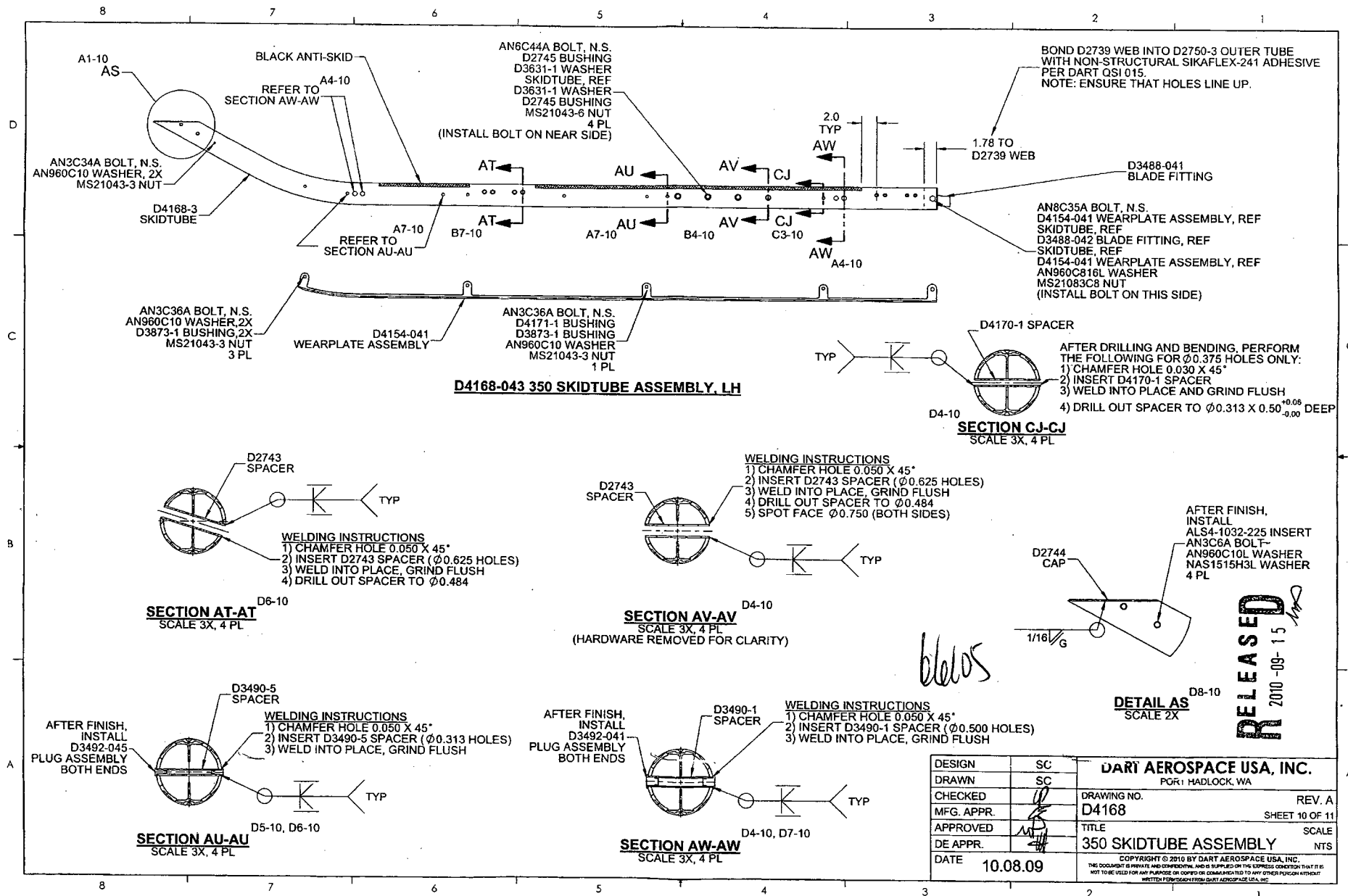
RELEASED
2010-09-15

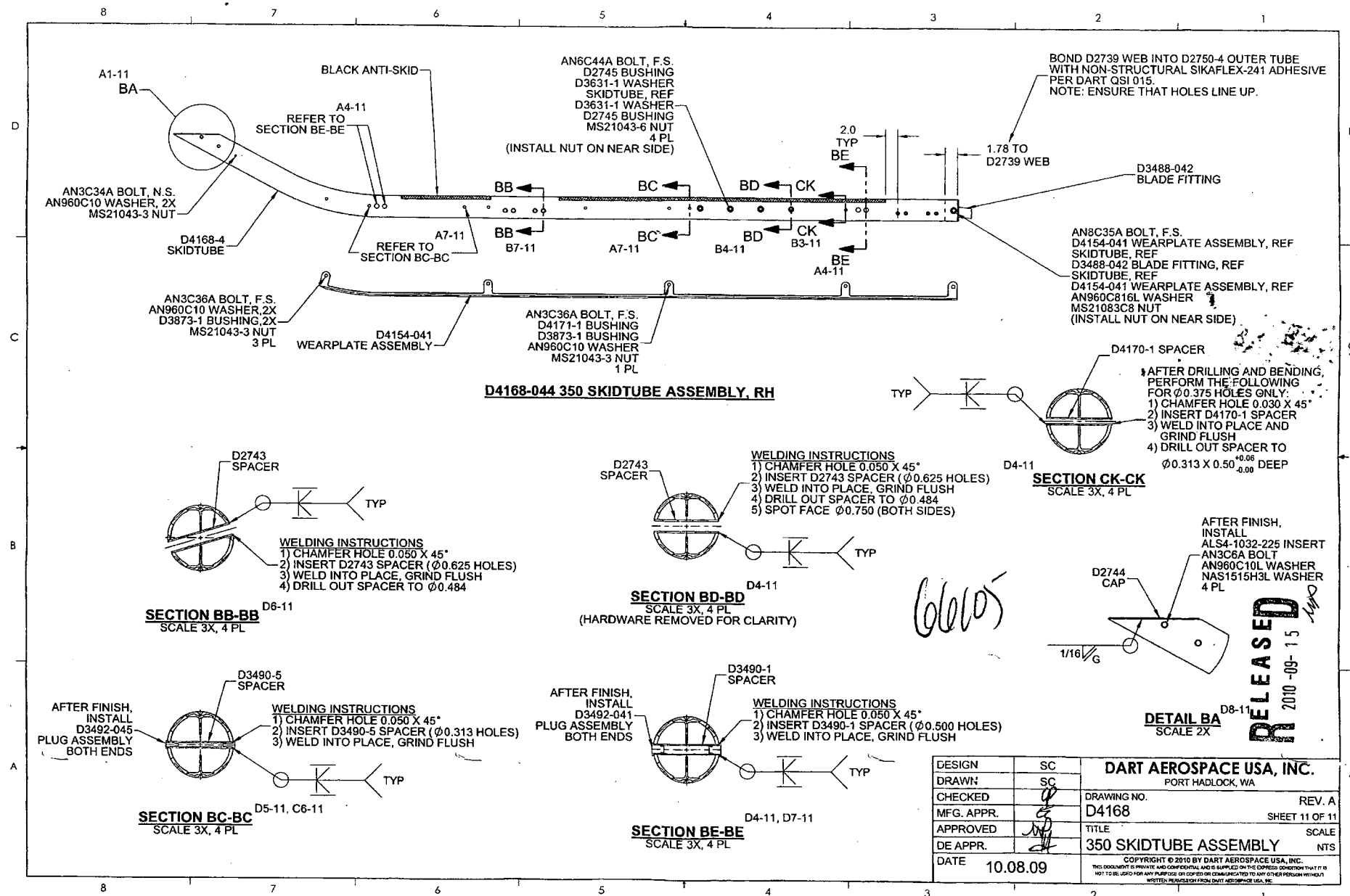
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1









NO. 243

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: ~~64950~~ 64953
Part number: J350-636-016
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Salv. Harris Date of Test Coupon 11-01-18

Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld